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Rush!!!

D5549-3
Job Sheet 183983



Part No: D5549-3

Job Qty: 2 ea

Part Name: Aft Beam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/1/18

Job Tracking No:

Due Date: 10/12/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG D5549 REV.B SHEETS 7, 8 IPP REV:A 17.09.01 NEW ISSUE DD VERF:DP IPP REV:B 18.01.17 AS
PER DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	2 pcs	10/12/18	10/12/18	0.00	4.13	Waterjet - Flow		18/10/31
110	QC	2 pcs	10/12/18	10/12/18	0.00	0.00	QC2 Waterjet-4		18/10/31
120	CNC Vertical Machining	2 pcs	10/12/18	10/12/18	0.00	8.66	HAAS1-4		
130	QC	2 pcs	10/12/18	10/12/18	0.00	0.00	QC2 Machining-4		11/11/18
140	QC	2 pcs	10/12/18	10/12/18	0.00	0.00	QC8 Machining-4		18/11/08
150	HandFinish	2 pcs	10/12/18	10/12/18	0.00	1.14	HandFinish1		18/11/08
160	QC	2 pcs	10/12/18	10/12/18	0.00	0.00	QC7-5		18/11/08
170	Powdercoat	2 pcs	10/12/18	10/12/18	0.00	0.22	Powdercoat1		18/11/08
180	QC	2 pcs	10/12/18	10/12/18	0.00	0.00	QC3		18/11/08
190	Packaging	2 pcs	10/12/18	10/12/18	0.00	0.00	Packaging3-2	NOV 09 2018	6 9-89
200	QC21-SA	2 Ea	10/12/18	10/12/18	0.00	0.00	QC21	NOV 09 2018	9-89 21 NOV 09 2018

Part Op 100 - 1-Cut contour and pockets as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr if necessary

Descriptions: 120 - Drill holes as per dwg manually on Hass4 Dwg rev: 4

170 - ***Mask holes or blow out access powdercoat in holes*** START TIME: 8:15 OVEN TEMPERATURE:

FINISH TIME: 8:25

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X8.000	6061T6 Bar 1.000 X 8.000	9.1600 ft (4.58 ea)	100-Waterjet - Flow - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6B1.000X8.000	9	15	0

Part Specifications

Specifications could not be found.

Plex 11/2/18 11:10 AM Dart.lajeunesse.marie

M6061T6B1.000X8.000
S119663

DART AEROSPACE LTD		Work Order:	183983
Description: Aft Beam		Part Number:	D5549-3
Inspection Dwg: D5549	Rev: B	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.50	± .030-.000	.530	1		V-D-02	
.65	± .030-.000	.680	1		Tap	
.50	+/- .030	.503	1			
3.50	+/- .030	3.497	1			
3.00	+/- .030	3.005	1			
1.25	+/- .030	1.280	1			
3.00	+/- .030	3.008	1			
7.23	+/- .030	7.23	1			
10.73	+/- .030	10.23	1			
11.23	+/- .030	11.23	1			
15.23	+/- .030	15.23	1			
19.23	+/- .030	19.23	1			
23.23	+/- .030	23.23	1			
27.23	+/- .030	27.23	1			
31.23	+/- .030	31.23	1			
35.23	+/- .030	35.23	1			
39.23	+/- .030	39.23	1			
43.23	+/- .030	43.23	1			
46.73	+/- .030	46.73	1			
53.36	+/- .030	53.36	1			
1.30	±0.030	1.300	/		Hammer	
1.300	±0.010	1.301	/		"	
1.500	"	1.500	/		"	
2.300	"	2.300	/		"	
0.60	±0.030	0.603	/		"	
0.76	"	0.755	/		"	
1.800	±0.010	1.801	/		"	
3.600	"	3.600	/		"	
3.36	±0.030	3.361	/		"	

Measured by: <u>DL</u>	Checked by: <u>[Signature]</u>	QC Inspector:
Date: 18/11/04	Date: 18/11/04	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

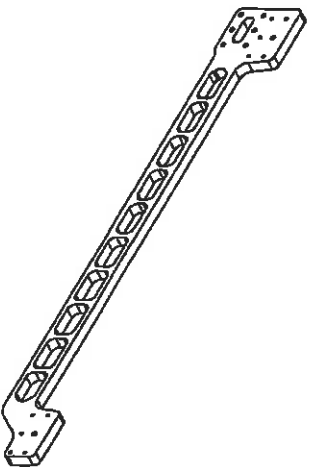
DQA: _____ Date: mid 19 June 2019
QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only



Work Order: <u>183983</u>		DISPOSITION ☒ Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved		AGAINST DEPARTMENT/PROCESS ☐ Skid-tube Machining ☐ Thermoforming Large Fab ☐ Cross tube Small Fab ☐ Finishing Composite ☐ Water Jet ☒ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ Engineering Quality ☐ Other	
Part No. <u>D5549.3</u>	NCR No. <u>19-7183</u>				
Date: <u>18-10-23</u>	Step #: <u>100</u>	QTY Effective: <u>①</u>		MRB (QSI042) Approval <u>18P 12 19/10/19</u>	
Description Work Order Deviation		Disposition		Completed By <u>19/10/19</u>	
Dimension <u>65" ± .03"</u> is at <u>.64"</u> and dimension <u>.50" ± .03"</u> is at <u>.488"</u> See attach drawing for dimensions.		Acceptable. Resulting second mentas are unchanged compared to SR-D117-1044-1 Rem A. Load to buckle local section: $P_{cr} = \frac{\pi^2 EI}{L^2} = \frac{\pi^2 (10.16 \times 10^6)}{(3.54)^2} = 49,000 \text{ lb}$ Requiring significantly higher bending moment than 19,364 and of SR by inspection.		QC / QA Coordinator Approval <u>18 13-11-02</u>	
Root Cause		FAULT CATEGORY		PD 13-11-02	
Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong
Design	Operator	Bending	Set-up	☒ Folio/Program	Outside Dimensions
Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance
Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing
Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved
Internal Transport	Poor Information	Crushing	Countersink	Off-set	Drawing
Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish
LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread
Substation	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence
Past Expiry Date	Manufacturing Process	OTHER :			
Misidentified	Past Due				



53,350

- APPROVED**

DESIGN		RF	DAIRT AEROSPACE USA, INC.		REV. B
DRAWN		RF	EUGENE, OR		SHEET 7 OF 8
CHECKED		WVK	DRAWING NO.		
MFG. APPR.		JFS	D5649		
APPROVED		HS	TITLE		
DE APPR.		DS	FWDA/DT BEAM ASSEMBLY		
DATE		17.09.27	COPYRIGHT © 2017 BY DAIRT AEROSPACE USA, INC. ALL RIGHTS RESERVED. NO REPRODUCTION OR TRANSMISSION OF THIS DOCUMENT IS PERMITTED WITHOUT THE WRITTEN PERMISSION OF DAIRT AEROSPACE USA, INC.		

FILED
2018-01-08

